












Date: Monday, 28/04/2008 3:42:58 PM
User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STRUT WELDMENT ASS'Y
Job Number	: 38848		
Estimate Number	: 10554		
P.O. Number	:	Part Number	: D34431
This Issue	: 28/04/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3443 REVB
First Issue	: / /	Project Number	: N/A
Previous Run	: 35214	Drawing Revision	: B
Written By	:	Material	:
Checked & Approved By	: <u>JL 08.4.29</u>	Due Date	: 10/05/2008
Comment	: A 05.11.14 New issue EC	Qty:	4 Um: Each
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	M174B2500X1250	17-4 SS BAR	
			
Comment: Qty.: 0.2100 f(s)/Unit Total : 0.8400 f(s) Material: 17-4 SS Bar 2.500" X 1.250" (M17-4-B2.500x01.250) Batch: <u>M101422</u> <u>mmf 08/05/16</u> (9)			
2.0	BAND SAW	BAND SAW	
			
Comment: BAND SAW Cut blank 2.400 " long <u>mmf 08/05/16</u> (9)			
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
			
Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folio FA587 Rev: <u>AA</u> & Dwg D3443 Rev: <u>B</u> <u>JL 08/05/18</u> (10)			
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>JL 08/05/18</u>			
5.0	QC8	SECOND CHECK	
			
Comment: SECOND CHECK <u>JL 08/05/22</u>			

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: D3443-1 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR: 38848		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/05/18	3.0	- two parts scrapped dimension .342 $\pm .005$ are under tolerance one is .329 the other .333	<i>[Signature]</i> 08/05/18	- scrap + replace QTY <u>610/422</u>	JL 08/05/18	<i>[Signature]</i> 08/05-22	<i>[Signature]</i> 08/05/18	S 08/05/18
		R.C. change foil instructions to hold part in center of use and	<i>[Signature]</i> 08/05/18	Folio updated see ATTACHED <i>[Signature]</i>	<i>[Signature]</i> 08-05-21	<i>[Signature]</i> 08/05/22	<i>[Signature]</i> 08/05/18	S 08/05/18

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT WELDMENT ASSY

Job Number: 38848

Part Number: D34431

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
Tumble & deburr per dwg D3443

I.L 08/05/22

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/05/22 (44)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

Part 0

Ref 23 (7)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/26

Job Completion



MF 08-05-23

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NOTE: Date & initial all entries

D3065-5DART AEROSPACE LTD		Work Order: 38848
Description: Lug		Part Number: D3443-1
Inspection Dwg: D3443	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.000	+/-0.010	.998	✓			
0.342	+0.000/-0.005	.342	✓			
0.329	+/-0.010	.326	✓			
Ø0.500	+0.000/-0.005	.4993	✓			
2.21	+/-0.030	2.215	✓			
Ø0.656	+0.000/-0.001	.655	✓			
0.625	+/-0.010	.624	✓			
0.95	+/-0.030	.953	✓			
2.230	+/-0.010	2.233	✓			
0.229	+/-0.010	.237	✓			
0.370	+/-0.010	.372	✓			
0.525	+/-0.010	.526	✓			
0.524	+/-0.010	.524	✓			
0.390	+/-0.010	.388	✓			
1.048	+/-0.010	1.050	✓			
0.05 x 45°	+/-0.5°	.057 x 45°	✓			
R0.032	+/-0.010	.032	✓			
0.470	+/-0.010	.469	✓			
0.165	+/-0.010	.165	✓			
1/4-28UNF	N/A					

Measured by: JL	Audited by: S.S.	Prototype Approval: N/A
Date: 08/05/18	Date: 08/05/18	Date: N/A

Rev	Date	Change	Revised by	Approved
A	06.07.11	New Issue	KJ/JLM	BE

W/O:		WORK ORDER CHANGES					
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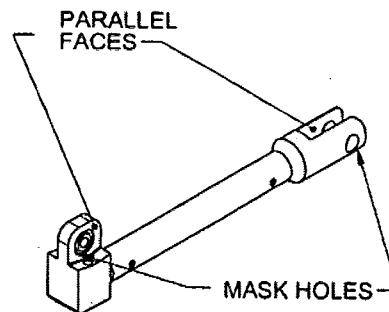
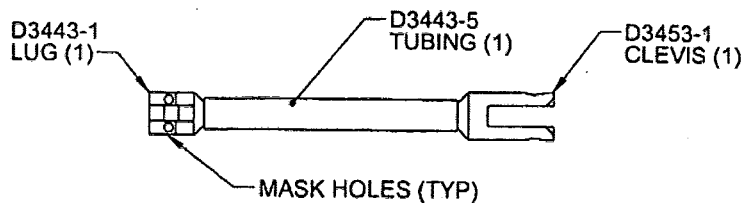
NOTE: Date & initial all entries



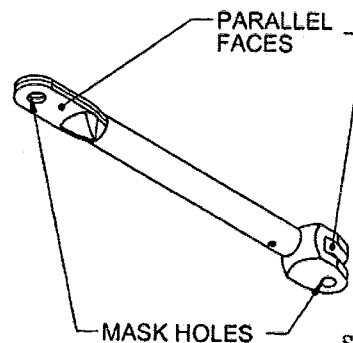
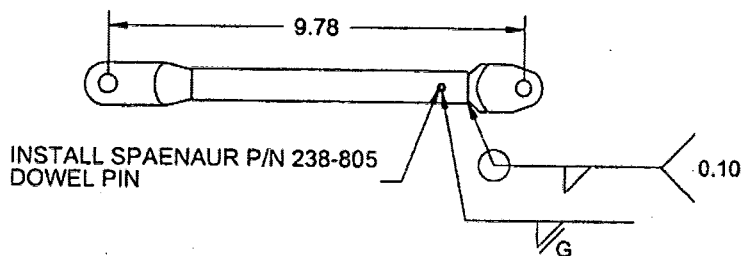
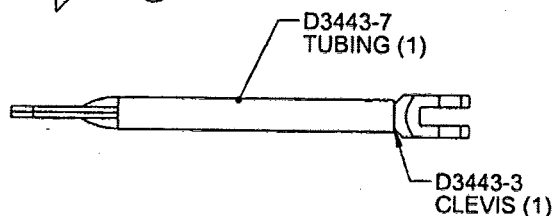
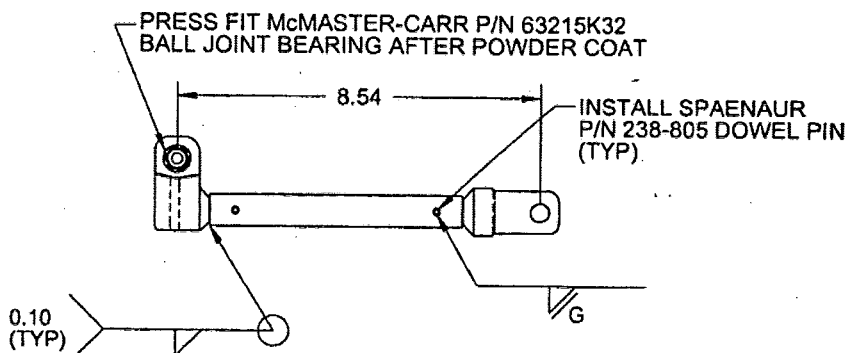
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3443	REV. B SHEET 1 OF 3
DATE 05.12.05		TITLE STRUT WELDMENT ASSEMBLY	SCALE 1:4
A	05.09.02	NEW ISSUE	
B	05.12.05	ADDED -9 PIN; REMOVED BALL PLUNGER; REVISE TOLERANCE; & $\phi 0.125$ WAS #30	

RELEASED

05.12.09 *[Signature]*



D3443-041



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SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 38898

NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

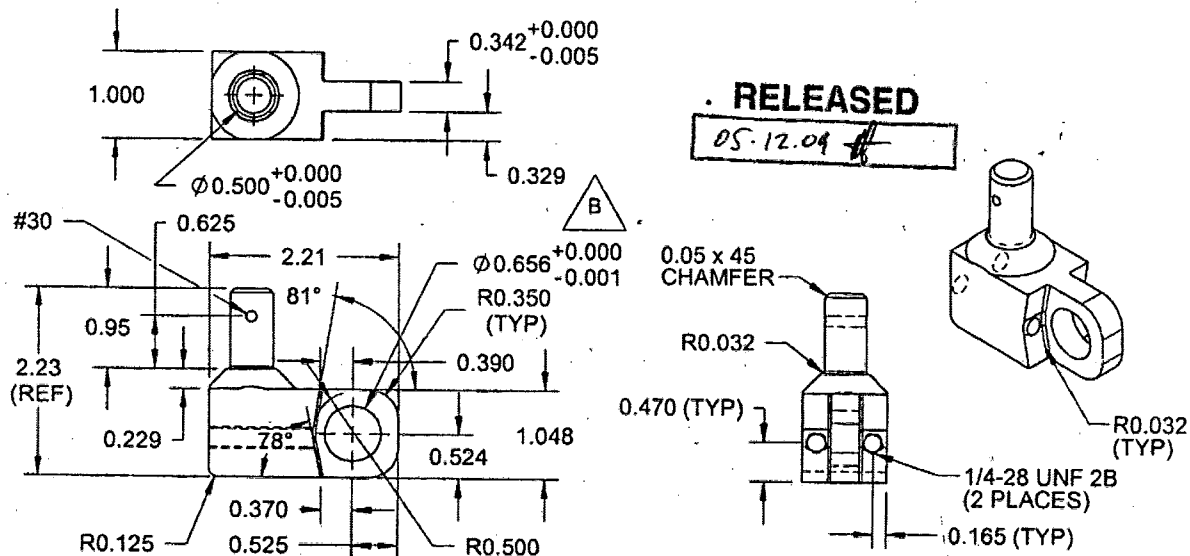
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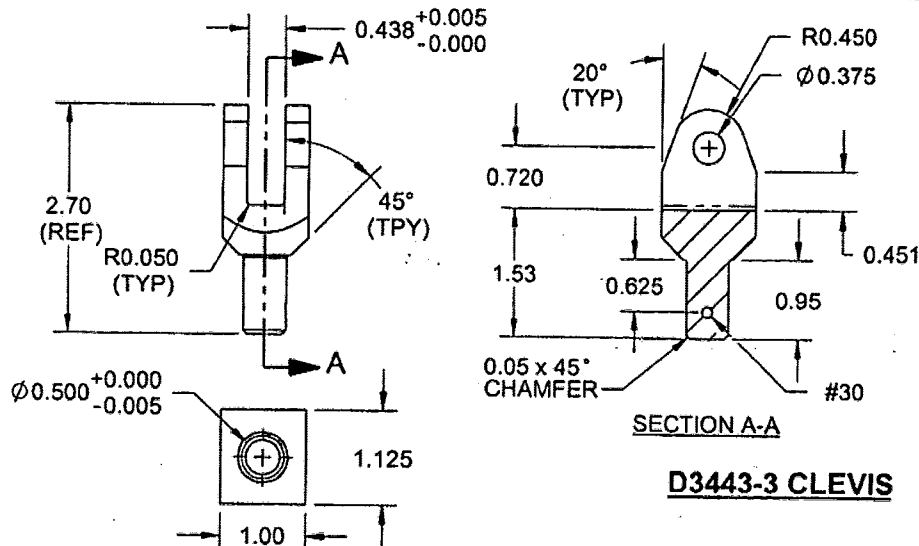
NOTE: Date & initial all entries

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3443	REV. B SHEET 2 OF 3
DATE 05.12.05	TITLE STRUT WELDMENT ASSEMBLY 1:2		

**D3443-1 NOTES:**

1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC M17-4B)

**D3443-3 NOTES:**

1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)

GENERAL NOTES:

- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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QA: N/C Closed: _____ Date: _____

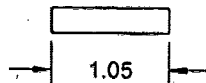
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3443	REV. B SHEET 3 OF 3
DATE 05.12.05		TITLE STRUT WELDMENT ASSEMBLY	SCALE 1:2

$\phi 0.210^{+0.005}_{-0.010}$



D3443-9 PIN

D3443-9 NOTES:

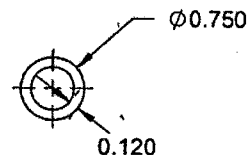
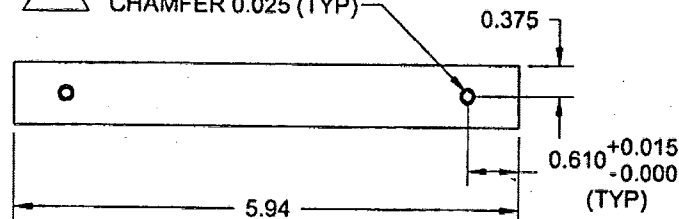
- 1) MATERIAL: DELRIN II 150R OR ACETRON GP ACETAIL (REF. DART SPEC M-DELRIN-R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED

05.12.09

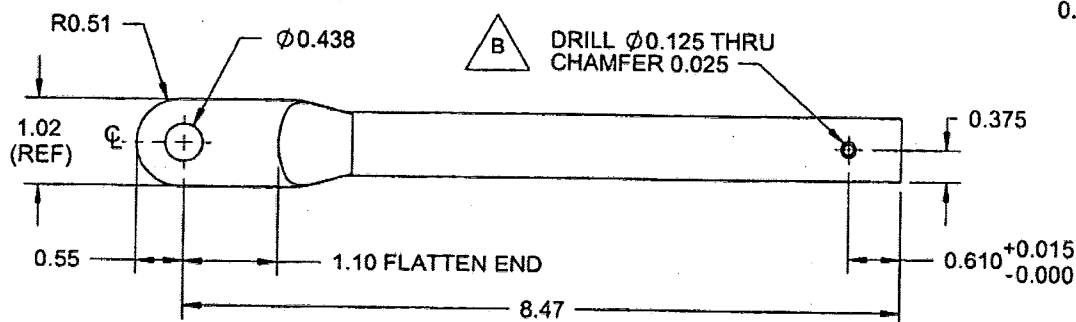
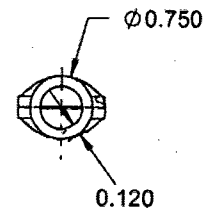
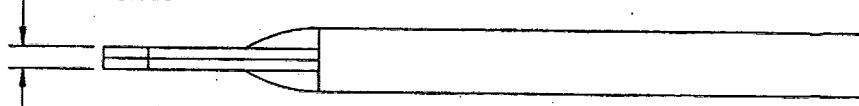


DRILL $\phi 0.125$ THRU
CHAMFER 0.025 (TYP)



D3443-5 TUBING

$0.260^{+0.000}_{-0.030}$



D3443-7 TUBING

D3443-5/-7 NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC M304TR0.7500W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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D3443-1 1ST OP

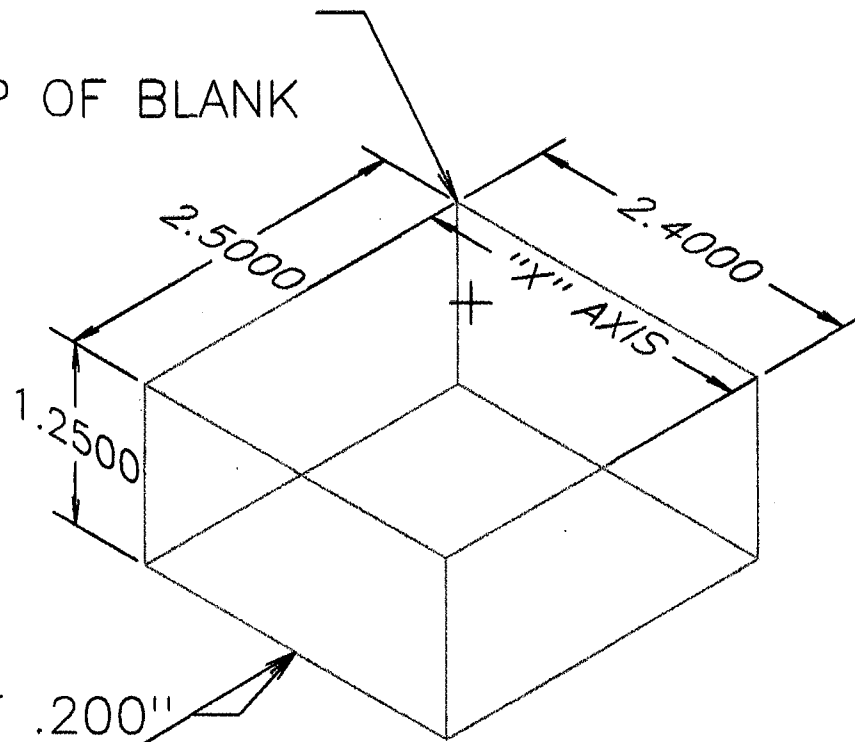
PROG #1000

G54:

X=0.0

Y=0.0

Z=0.0 TOP OF BLANK



HOLD BY MAX OF .200"

HOLD IN MIDDLE OF VISE TO ENSURE MORE HOLDING POWER